Rear Floor/Rear Floor Cross-member

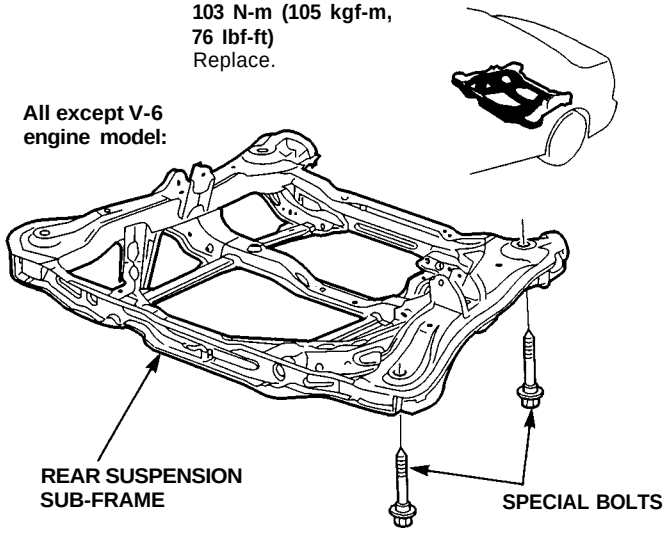
Replacement

1. Remove the related parts.
   - Rear seat
   - Trim and other luggage compartment fittings
   - Left and right rear suspension assembly
   - Parking brake parts
   - Muffler
   - Wire harness
   - Other parts as necessary
2. Disconnect the fuel lines and remove the rear suspension sub-frame.

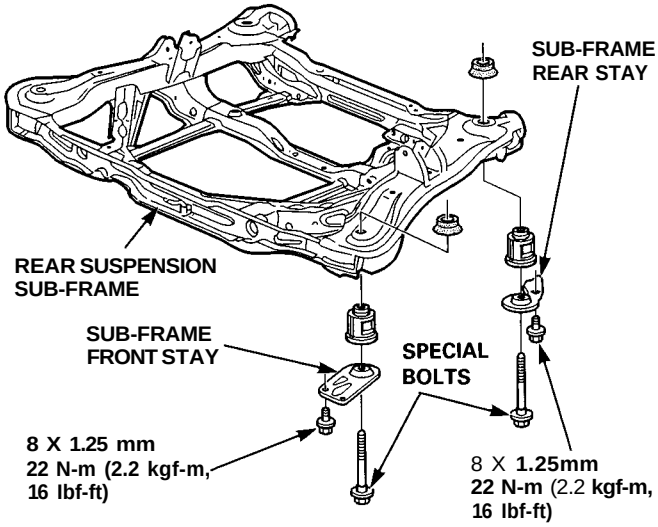
WARNING **Do not smoke while working near the fuel system. Keep open flame away from the fuel system. If necessary, remove the fuel tank and/or lines before welding nearby. Drain fuel into an approved container.**

SPECIAL BOLT: 14 X 1.5 mm
103 N-m (105 kgf-m, 76 lbf-ft)
Replace.

All except V-6 engine model:

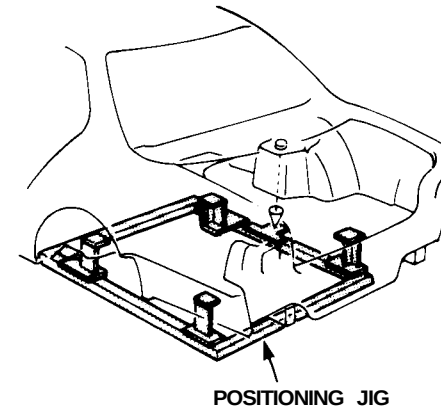


V-6 engine model:



3. Pull out and straighten the damaged area.
   - Check whether the damage extended to the rear floor cross-member, rear wheelhouse, and the passenger compartment. Pull out the damaged parts using the frame corrector.
   - Impact damage to the rear floor spreads to related parts such as the rear frame, rear floor cross-member, and rear wheel house.
   - Therefore, pull out the damaged areas with the frame straightener and measure in reference to body dimensional drawing.

NOTE: Use of a positioning jig is recommended (see page 1-8).



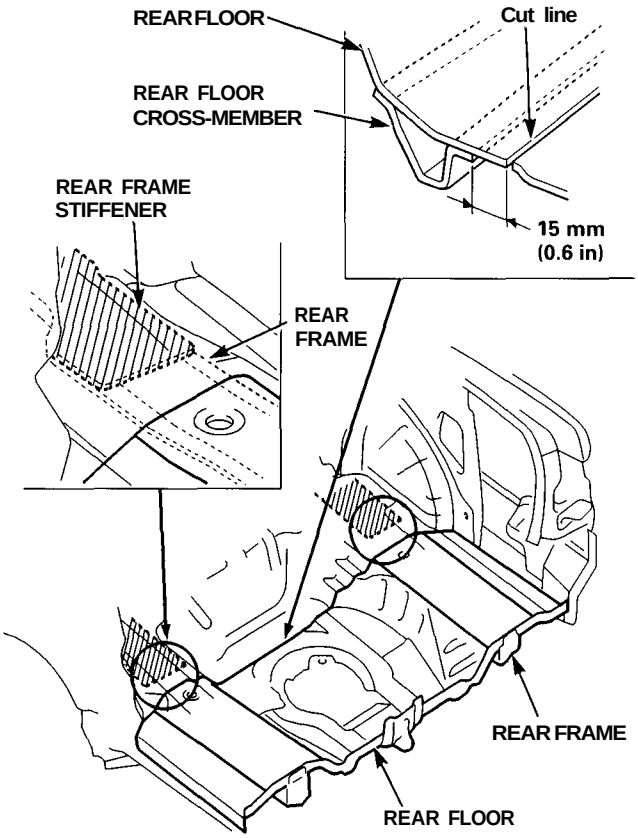
4. Peel off the undercoat. Heat the undercoat at the weld areas of the lower rear floor with a gas torch and peel off the undercoat with a metal spatula.

CAUTION: Be careful not to burn the fittings inside the trunk compartment and rear wheelhouse insulator while heating.

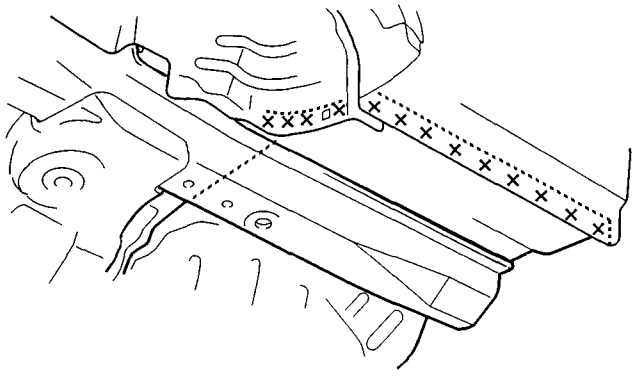
5. Cut and pry off the rear panel (see pages 4-46, 4-47).

6. Cut and pry off the rear floor.
   - Cut off the rear floor with a gas cutter or air chisel.
   - Leave the spot welded flanges of the rear frame and rear floor cross-member shown by the bold line in the figure below.

   NOTE:
   - Cut the rear floor 15 mm (0.6 in) from the welded flange of the rear floor cross-member.
   - Do not cut or damage the rear frame stiffener.



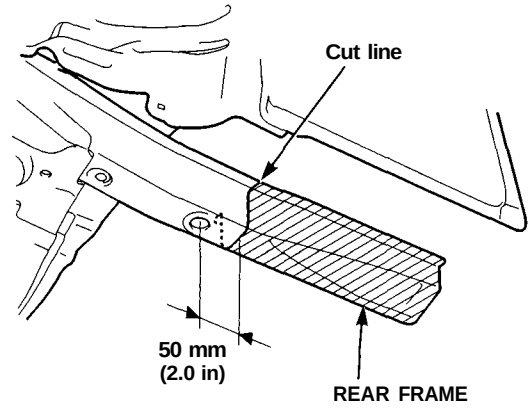
   - Center punch around the spot weld imprints on the remaining welded flanges.
   - Drill holes with a spot cutter.

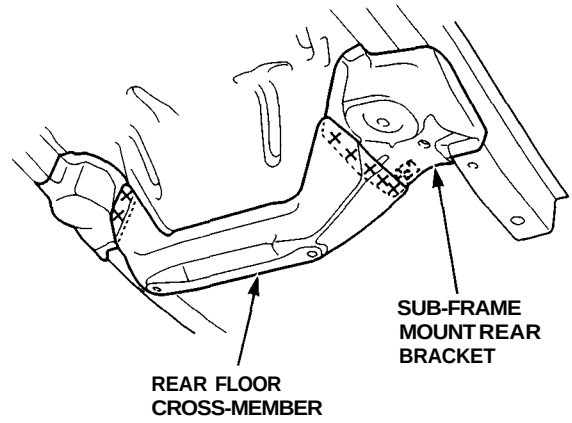


7. Check the damage and position of the rear frame and rear floor cross-member.
   - Smooth the welding flanges of the rear frame with a hammer and dolly.

   NOTE: Check that the rear frame is parallel at the right and left.

8. If necessary, cut the rear frame, and replace the rear floor cross-member.





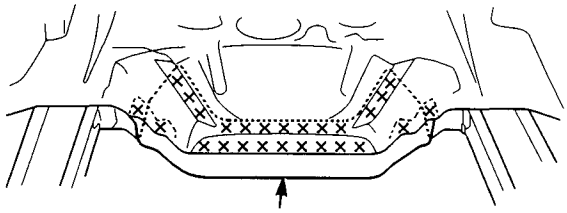
   - Strike a center punch around the spot weld imprints on the rear floor cross-member from inside the trunk compartment.
   - Drill out the spot welds with the spot cutter.

   NOTE: Keep the holes to a minimum since they will be used as weld holes MIG welding of the new part.

(cont'd)

Rear Floor/Rear Floor Cross-member

Replacement (cont'd)



9. Straighten the related parts.
   - Remove the burrs from the spot weld or MIG weld using a sander.

   ⚠WARNING To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting, or grinding.

   - Fill any holes made in the spot welded areas of the flange by MIG or gas welding.

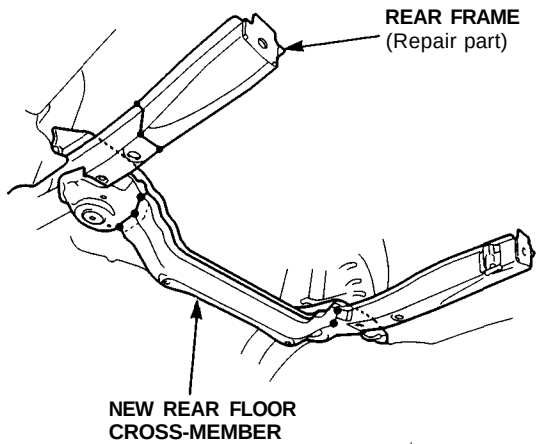
   ⚠WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, groves, and safety shoes.

10. Keep the body level.
    Jack the body at the front and back. Place safety stands at the four designated places of the side sill.

11. Set the new rear floor cross-member and rear from (repair part), and check the position of the rear frames using the body dimensional drawings (see section 6) and the positioning jig.

12. Tack weld the new rear floor cross-member and rear frame (repair part).

    ⚠WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, groves, and safety shoes.

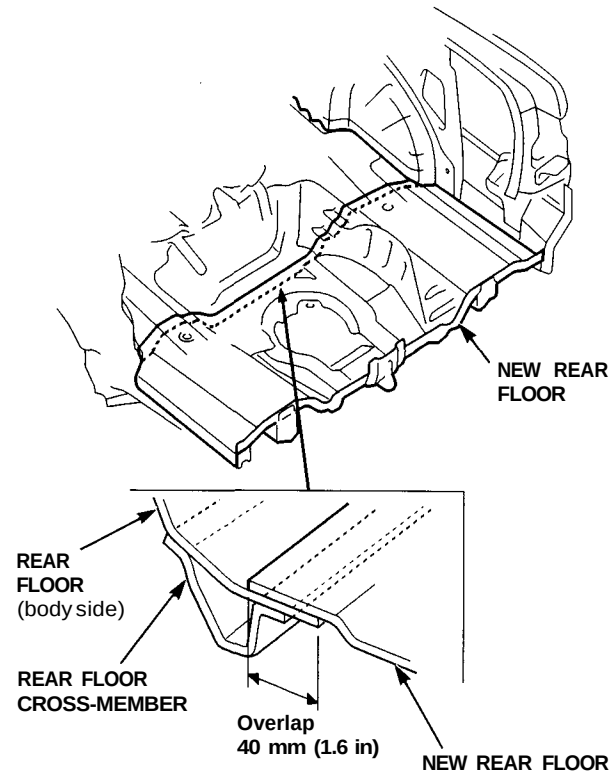


13. Cut the new rear floor to align it with the body.

    NOTE: Cut the new part so it overlaps the body side floor by approximately 40 mm (1.6 in).

    Remove the undercoat from both sides of the areas to be welded with a sander to expose the steel plate.

    ⚠WARNING To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting, or grinding.



14. Clamp the new rear floor, and check the position of the rear wheelhouse, inner panel and outer panel.

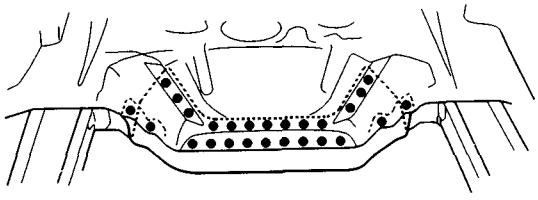
15. Check the rear frame in its correct position with the rear sub-frame installed.

16. Remove the new rear floor.

17. Weld the rear floor cross-member and rear floor (body side).

⚠WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

NOTE: Weld as much as possible with the positioning jig still mounted.



18. Finish the welding area.
Roughly grind the welds in the trunk compartment with a disc grinder. Be sure to leave the finishing allowance.

NOTE: Take care not to grind excessively.

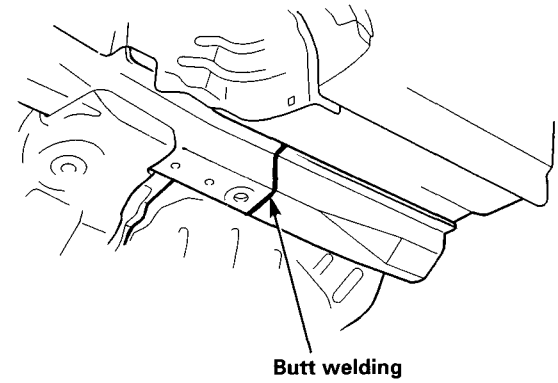
19. Set the new rear floor.
- Drill the holes for welding the new rear floor.
- Check that the weld flange surfaces fit closely.
- Tack weld the new rear floor.

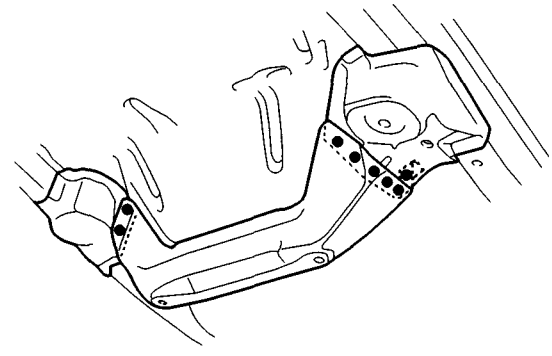
⚠WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

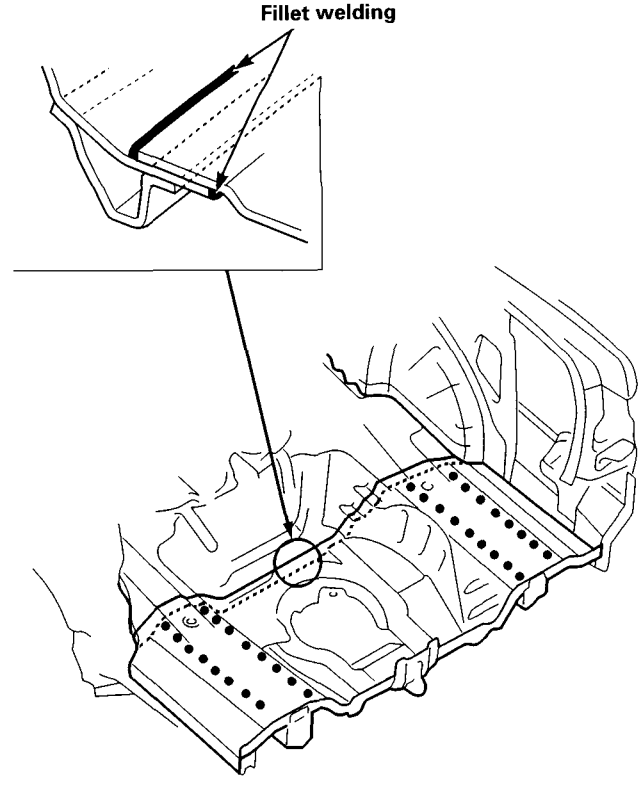
20. Clamp the rear panel and check the outer panel and trunk gutter position.
Remove the rear panel.

21. Main weld the new rear floor, rear frame (repair part) and rear floor cross-member.

⚠WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.







(cont'd)

Rear Floor/Rear Floor Cross-member

Replacement(cont'd)

- Weld the rear panel (see page 4-51).

22. Finish the welded area.
    Even out the welded area with a hammer and dolly , and fit the flange surfaces closely together.

23. Apply sealer at the overlapped area of the rear floor, and the welded surfaces of the rear wheelhouse and rear end inner panel. Seal gaps completely (see section 5).

24. Apply the paint. See Paint Repair section.

⚠ WARNING

- **Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.**
- **Avoid contact with skin. Wear an approved respirator, gloves, eye protection, and appropriate clothing when painting.**
- **Paint is flammable. Store it in a safe place, and keep it away from sparks, flames, or cigarettes.**

25. Apply the undercoat.
    Apply anti-rust agent to the inside of the rear floor cross-member, jack-up stiffener, and jointed areas of the rear floor (see section 7).

26. Weld the rear panel and install the related parts.
    Install in the reverse order in which they were removed.

27. Inspect and clean.
    - Measure the rear Wheel alignment.
    - Clean the inside of the trunk compartment.